

Date: Monday, 6/26/2006 8:02:35 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 27679
 Estimate Number : 12403
 P.O. Number : *N/A*
 This Issue : 6/26/2006 S.O. No. : *N/A*
 Prsht Rev. : NC
 First Issue : 6/26/2006 Type : SMALL /MED FAB
 Previous Run : 27194

Drawing Name : WEARPLATE

Part Number : D3511041
 Drawing Number : D3511 REV A
 Project Number : N/A
 Drawing Revision : A
 Material : *NM*
 Due Date : 6/30/2006

Qty: 20 Um: Each

Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est Rev:A New Issue 06-05-04 JLM
 Est Rev:B New process 06-05-05 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S188 304 SHEET .188" THICK



Comment: Qty.: 1.5572 sf(s)/Unit Total : 31.1430 sf(s)
 304 SHEET .188" THICK
 (M304S0188)
 Batch: *H101104*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3511
 Dwg. Rev: *A*
 Prog Rev: *A*

2-Debar if necessary

Identify as D3511-1

1/1A spec sequence 6.0

SAD 06:06:26

(14)

PTD on back

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J 06/10/31 (14)

Date: Monday, 6/26/2006 8:02:35 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27679

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D35031

CUP



Comment: Qty.: 8.0000 Each(s)/Unit Total: 160.0000 Each(s)

CUP

Batch:

B27198

CPL 06-12-05

(14)

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary

SAD

06/11/08

(14)

2-Bend fwd 90 deg. bend per dwg D3511

SB

06/11/14

(14)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch:

M102756

CPL 06-12-06

(14)

8.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

06/12/06

(14)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

SB 06/12/18

(14)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/12/18

(14)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-H/a.n

06/12/20

(14)

Date: Monday, 6/26/2006 8:02:35 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27679

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PU 7/21/03

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CB 07/01/03 (14)

PU 7/21/03

14.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07.01.04

Job Completion



C207101104

Date: 6/23/2006 11:24AM
User: Linda Lacelle

PROCESS SHEET

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job No.	: 27679	Part No.	: D3511041
Estimate No.	: 12403	Drawing No.	: D3511 REV A
P.O. No.	: SO No.	Drawing Rev.	: A
First Issue	: / /	Project No.	: N/A
Prsht Rev.	: NC	Material	:
This Issue	: 6/23/2006	Due Date	: 6/30/2006
Prev. Run	: 27194	QTY:	: 20
Type	: SMALL /MED FAB		

Written by: _____
 Checked & Approved by: _____
 Comment : Est Rev:A New Issue 06-05-04 JLM
 Est Rev:B New process 06-05-05 EC

Job Number:



Seq. No.	Machine or Operation	Description
1.0	M304S188	304 SHEET .188" THICK
	Comment: Qty.: 1.5572 sf(s)/Unit Total : 31.1430 sf(s) 304 SHEET .188" THICK (M304S0188) Batch:	
2.0	WATER JET	FLOW WATER JET
	Comment: FLOW WATER JET 1-Cut as per Dwg D3511 Dwg Rev: _____ Prog Rev: _____ 2-Deburr if necessary Identify as D3511-1	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	
5.0	D35031	CUP
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 160.0000 Each(s) CUP Batch:	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06/11/15	6.1	Qc S inspection (permenent change)	MA	06/11/15		<i>[Signature]</i> 07-01-04	<i>[Signature]</i> 02-01-04	
07-01-04	22	Remove delay step. Delay is at sequence 6.0. Perm. Change.	→			<i>[Signature]</i> 07-01-04	<i>[Signature]</i> 07-01-04	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Number:



Seq. No.	Machine or Operation	Description
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Debur if necessary 2-Bend fwd 90 deg. bend per dwg D3511	
7.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
	Comment: LARGE FABRICATION RESOURCE 1 Weld as per Dwg D3511 A/R SS ROD Batch:	
8.0	QC5/9	WELD INSPECTION
	Comment: WELD INSPECTION	
9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Form as per Dwg D3511	
10.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
11.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3	
12.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
13.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:	
14.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	

Job Completion



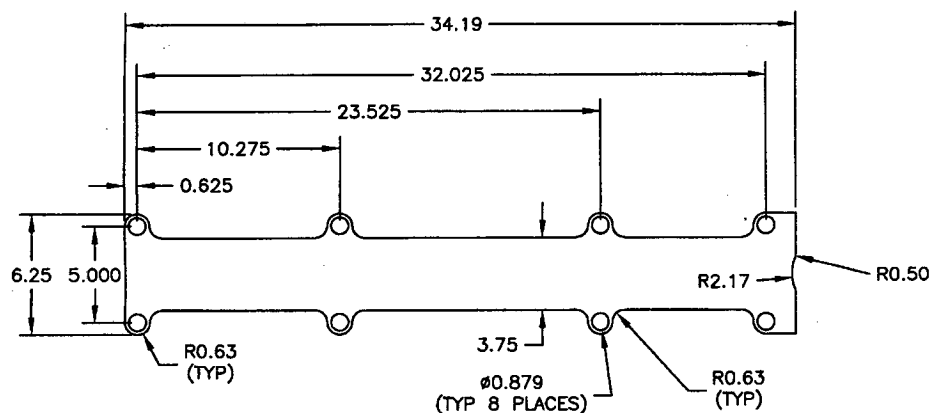
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

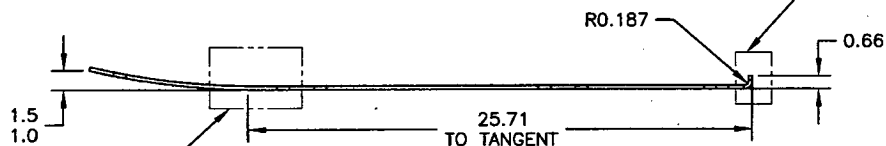
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



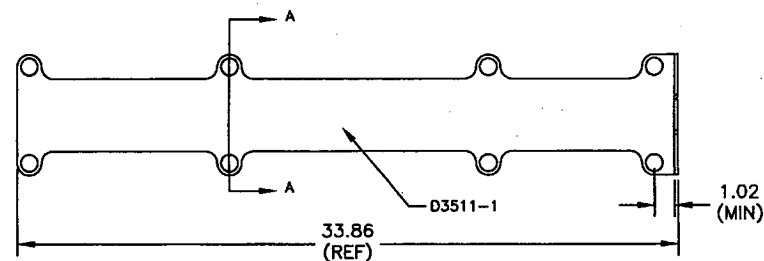
D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



D3511-1 BEND DETAIL

NOTE: BEND AFTER WELDING



SECTION A-A

D3511-041 WELD DETAIL

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: **ASI 304/316 STAINLESS STEEL (0.188 THICK)**
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
3	D3503-1	CUP

REFERENCE ONLY

REFERENCE ONLY

RELEASED

06 04 25 #

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A	06.04.04	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED J.H.	APPROVED #	DRAWING NO. D3511
DATE 06.04.04	TITLE WEARPLATE	REV. A SHEET 1 OF 1 SCALE MTS

